



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

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RBT200078
Job Sheet 188030



Part No: RBT200078

Job Qty: 1 ea

Part Name: Trunnion Bearing Removal & Install Work Aid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/2/19

Job Tracking No:

Due Date: 1/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT200078 Rev. 2A IPP Rev. A 18.07.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/2/19	1/2/19	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	1 pcs	1/2/19	1/2/19	0.00	0.07	Small Fab-9		
110	QC	1 pcs	1/2/19	1/2/19	0.00	0.00	QC5		
130	Packaging	1 pcs	1/2/19	1/2/19	0.00	0.00	Packaging3-2		
140	QC21-FG	1 Ea	1/2/19	1/2/19	0.00	0.00	QC21		

Part Op 100 - Assemble as per DWG.
Descriptions: 130 - Bag and tag

DAG
21
9-89

JAN 02 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT200078-1	Trunnion Bolt (Hex Head Cap Screw)	1 Ea (1 ea)	90-Start up Operation	5133365
RBT200078-2	Trunnion Body	1 Ea (1 ea)	90-Start up Operation	5105226
RBT200078-3	Trunnion Spreader	1 Ea (1 ea)	90-Start up Operation	5105250

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBT200078-1	1	4	0
	RBT200078-2	1	2	0
	RBT200078-3	1	2	0

Part Specifications

Specifications could not be found.



Container No: S141080



Part: RBT200078

Job No: 188030

Serial No/Batch: S141080

Revision: 2A

Inspector:

Exp Date:

Instructions:

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CANADA
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Plex 1/2/19 7:37 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

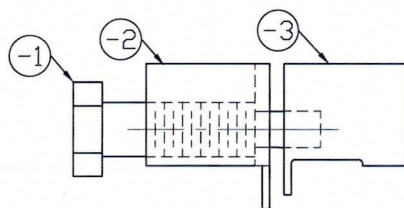


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

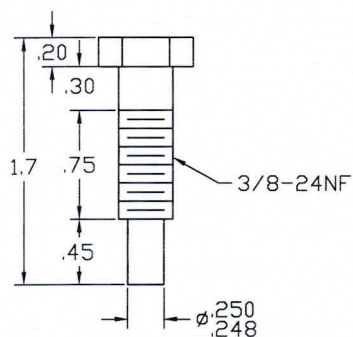
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



ASSEMBLY VIEW

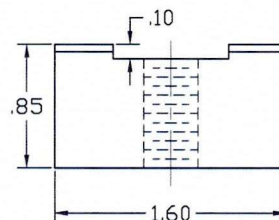
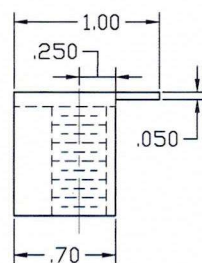
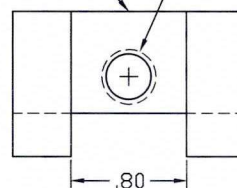


(-1)

BOLT

3/16 TEXT "RBT200078"

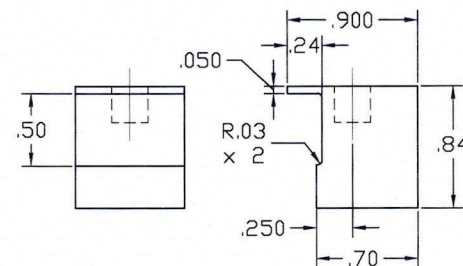
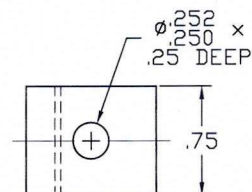
DRILL & TAP
3/8-24NF THRU



(-2)

BODY

HEAT TREAT 35-40 Rc



(-3)

SPREADER
HEAT TREAT 35-40 Rc

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED BOLT PIN FROM #.247, AND -3 HOLE FROM #.250; ALSO CHANGED P/N FROM T200078	8/16/06	WP	-
2	ADDED NEW TITLE BLOCK, BOM, & REVISIONS TABLE, AND ASSEMBLY VIEW. ALSO CHANGED MATERIAL DISCRPTION FROM 1 in. WIDE.	3/6/08	WP	RW
2A	CH'D BOM LENGTH FROM 13/16 TO 7/8 -3 PER R.W.	12/17/10	RJC	RW

ASSY QTY	W/D	PART #	UNIT QTY	DESCRIPTION	MAT.	B/D INFORMATION OR SPECIFICATIONS
	-1	1	1	HEX HEAD CAP SCREW	BLACK	3/8-24 x 1-3/4
	-2	1	1	BODY	4140	1 x 1-1/4 x 1-3/4
	-3	1	1	SPREADER	4140	1 x 1-1/4 x 7/8
ASSY						

RED BARN MACHINE			
TITLE TRUNNION BEARING REMOVAL AND INSTALLATION WORK AID			
DWG NO. RBT200078		REV 2A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: COLE	
TOLERANCES ON:		APPROVED <i>D Weil</i>	
DECIMALS .XXX ± .005		HEAT TREAT LISTED BY PART	
FRACTIONS ± 1/32		FINISH BLACK OXIDE	
ANGLES ± 5°		USED ON MODEL	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R		BELL 204, 205,	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		206, 212	
SCALE NTS	DATE 10-15-01	SHEET 1 of 1	